

Work Order ID 70140-2
Friday, May 27, 2011 2:53:39 PM



Page 1

Item ID: D4008-041

Revision ID:

Item Name: Fuel Filler Splash Guard Assembly

Start Date: 5/27/2011 Start Qty: 3.00

Required Date: 6/30/2011 Req'd Qty: 3.00

Reference:

Approvals:

Process Plan: *MF*

QC:

Date: 11-05-27

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4008

100



Waterjet

FLOW CNC Waterjet

6061 - 035

Memo

1-Cut as per Dwg (D4008-1)

Dwg Rev: *H*

Prog Rev: *H*

2-Deburr if necessary

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

0.00

0.00

Cust Item ID:

Customer:

Setup Start

Stop

11-05-30

11-05-30

110



QC

Quality Control

Work Order ID 70140

Friday, May 27, 2011 2:53:39 PM



Page 2

Item ID: D4008-041

Accept



Setup Start



Revision ID:

Item Name: Fuel Filler Splash Guard Assembly

Stop



Start Date: 5/27/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

8/16/31

(KB)

130



Brake NC

Brake NC

Bend as per dwg

Memo

Bend D4004-1 as per Dwg

0.00

0.00

8/16/06

(L)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/16/06

(+6)

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Item ID: D4008-041

Accept



Setup Start



Revision ID:

Item Name: Fuel Filler Splash Guard Assembly

Stop



Start Date: 5/27/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 3.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hard Finishing

6x Ø m-f 11/06/06

160



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

Powder Coating

REMOVE PIN PRIOR TO POWDERCOATING

Start Time:

Oven Temperature:

Finish Time:

9:15
9:45
3:20 PM

6x Ø m-f 11/06/08

170



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

6x 11-6-8

M115128

Work Order ID 70140

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Item ID: D4008-041

Accept



Setup Start



Revision ID:

Item Name: Fuel Filler Splash Guard Assembly

Stop



Start Date: 5/27/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg

Handwritten: 5/27/21 ①

190

0.00



QC

QC'S- Inspect part-completeness to step on W/O

Memo

0.00

Quality Control

Handwritten: ml 11 07 21 ①

200

0.00



Packaging

Identify as per dwg & Stock Location

Memo

0.00

Packaging

Handwritten: 108

Handwritten: 11/7/21 ①

Work Order ID 70140

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Item ID: D4008-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Filler Splash Guard Assembly

Start Date: 5/27/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 3.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/22 JF
MF
11-07-21

Picklist Print

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Page 1

Work Order ID: 70140

Parent Item: D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly



Start Date: 5/27/2011

Required Date: 6/30/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP rev A 10.01.27 New issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.032

Purchased

No

100

sf

10.0000

0.2735

0.863684



6061-T6 Sheet 0.032"

Location

Loc Qty

Loc Code

MAT021

10

110063

3

16954

7

D4008-5

Manufactured

No

180

Each

5.0000

1

3



Fuel Filler Splash Guard Hinge Half

Location

Loc Qty

Loc Code

GA

2

64629

2

ST102

3

67689

3

D4008-9

Manufactured

No

180

Each

0.0000

1

3



Spring

D4008-7

Manufactured

No

180

Each

7.0000

2

6



Washer

Location

Loc Qty

Loc Code

ST108

7

59662

7

1311-5-36

112763 (6)

EP 11/07/19

B70913 (12)

EP 11/07/19

EP 11/07/19 B70946 (2x)

Picklist Print

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Work Order ID: 70140

Parent Item: D4008-041

Parent Item Name: Fuel Filler Splash Guard Assembly



Start Date: 5/27/2011

Required Date: 6/30/2011

Start Qty: 3.00

Required Qty: 3.00

MS20470AD3-3 Purchased No
Rivet, Universal Head



180 Each 9,609.000 5 15



Handwritten: 5/11/07/19

Location	Loc Qty	Loc Code
ST319	9609	
1065	1435	
16941	8174	

MS21042L08 Purchased No
Nut



180 Each 460.0000 2 6



Handwritten: 5/11/07/19

Location	Loc Qty	Loc Code
ST300	460	
117441	10	
117601	200	
117677	100	
117739	150	

MS35206-S245 Purchased No
Screw



180 Each 82.0000 2 6



Handwritten: M/18242 (2x)

Location	Loc Qty	Loc Code
ST294	82	
113898	82	

NAS1149DN832J Purchased No
WASHER



180 Each 1,206.000 6 18



Handwritten: 5/11/07/19

Location	Loc Qty	Loc Code
ST297	1206	
117316	1206	

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Shop Packet Print

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Picklist Print

Page 3

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Parent Item: D4008-041



Parent Item Name: Fuel Filler Splash Guard Assembly

Start Date: 5/27/2011

Required Date: 6/30/2011

Start Qty: 3.00

Required Qty: 3.00

D3941

Manufactured

No

180

f

44.7790

0.21

0.663158



Rubber Cushion

Location

Loc Qty

Loc Code

ST408

44.77895

48512

44.77895

cut 1.25" long

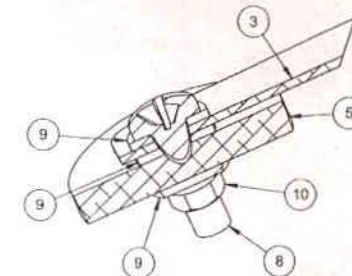
Handwritten signature
5/27/11
~~0.6~~ 1.05

Friday, May 27, 2011 2:53:35 PM

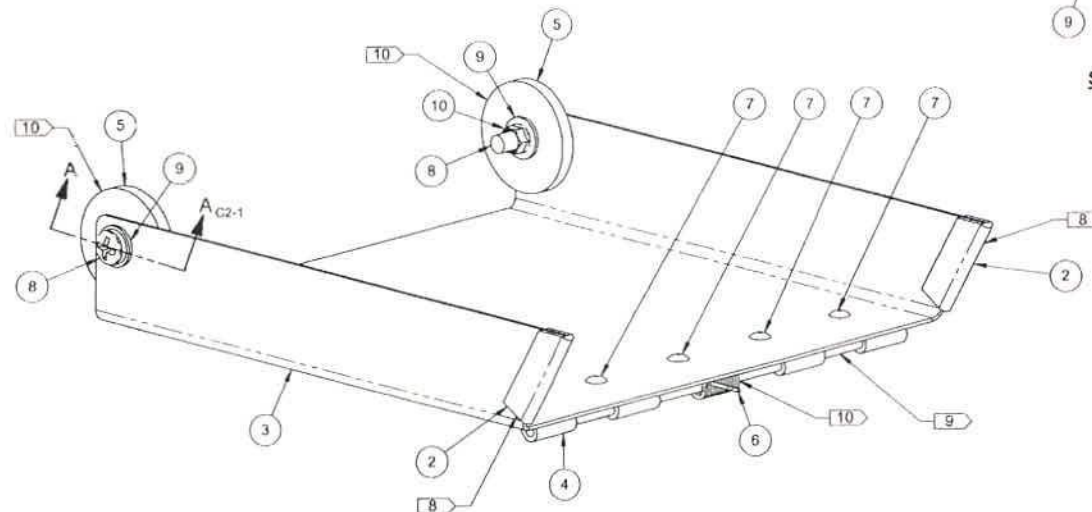
Shop Packet Print

Page 3

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-041	AUX TANK FILLER SPLASH GUARD ASSEMBLY	JCA-M47-2-26
2	2	D3941-1	RUBBER CUSHION	
3	1	D4008-1	FUEL FILLER SPLASH GUARD CHANNEL	
4	1	D4008-5	HINGE HALF	
5	2	D4008-7	WASHER	
6	1	D4008-9	SPRING	
7	5	MS20470AD3-3	RIVET	
8	2	MS35206S245	SCREW	
9	6	NAS1149DN832J	WASHER	
10	2	MS21042L08	NUT	



SECTION A-A
SCALE: 2X
B6-1
TYP



D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.15 lbs
- 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT
- 9) MASK HINGE PIN AREA BEFORE POWDER COAT
- 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT

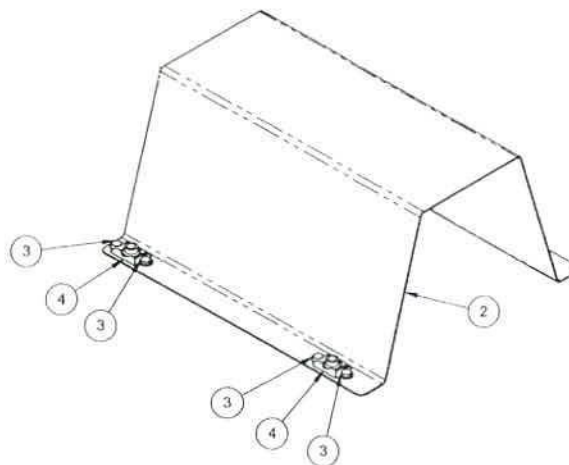
B	ADD ALTERNATE RIVETS FOR -043, ZN D7-2	HS	10.11.03
A	NEW ISSUE	HS	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4008	REV. B
TITLE SPLASH GUARD	SHEET 1 OF 10
SCALE NTS	

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RELEASED
2011-05-30
MM

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-043	FUEL PUMP SPLASH GUARD ASSEMBLY	JCA-M47-2-29
2	1	D4008-3	FUEL PUMP SPLASH GUARD COVER	
3	8	MS20472M3-3	RIVET	B
4	4	MS21060L3	ANCHOR NUT	B



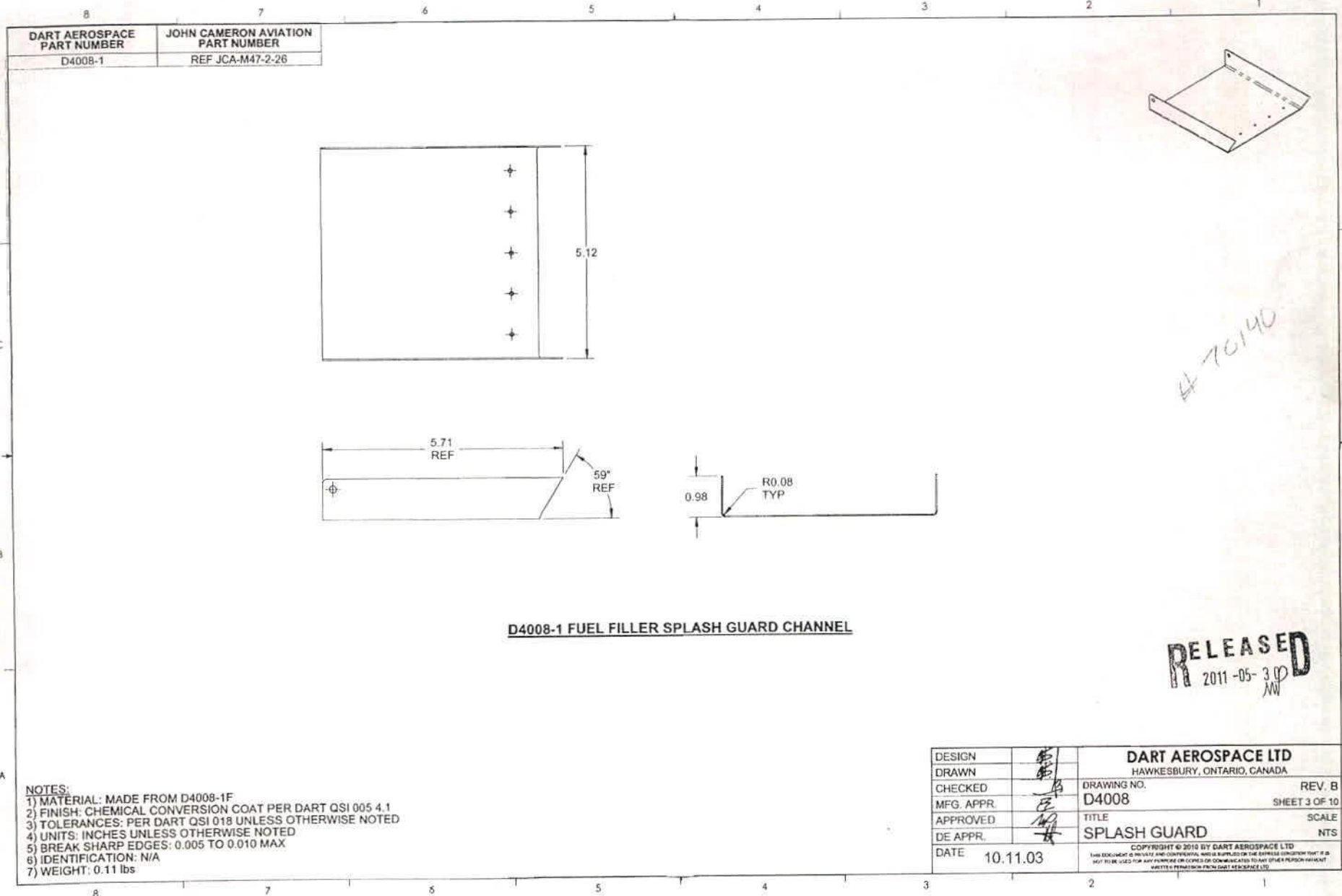
D4008-043 FUEL PUMP SPLASH GUARD ASSEMBLY

NOTES:

- 1) MATERIAL:
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.46 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4008	SHEET 2 OF 10
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2011-05-30
JW



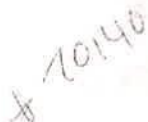
470140

D4008-1 FUEL FILLER SPLASH GUARD CHANNEL

RELEASED
2011-05-30

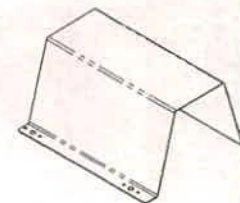
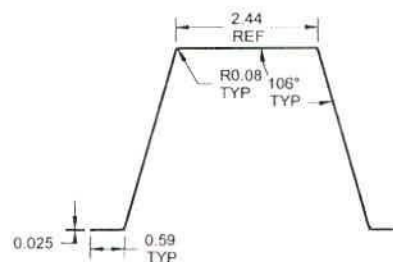
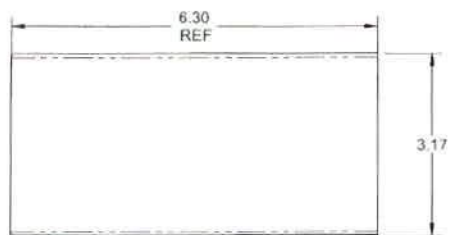
- NOTES:
- 1) MATERIAL: MADE FROM D4008-1F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.11 lbs

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MFG. APPR.		D4008	SHEET 3 OF 10
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RELEASE
2011-05-30
JW

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-3	REF JCA-M47-2-29

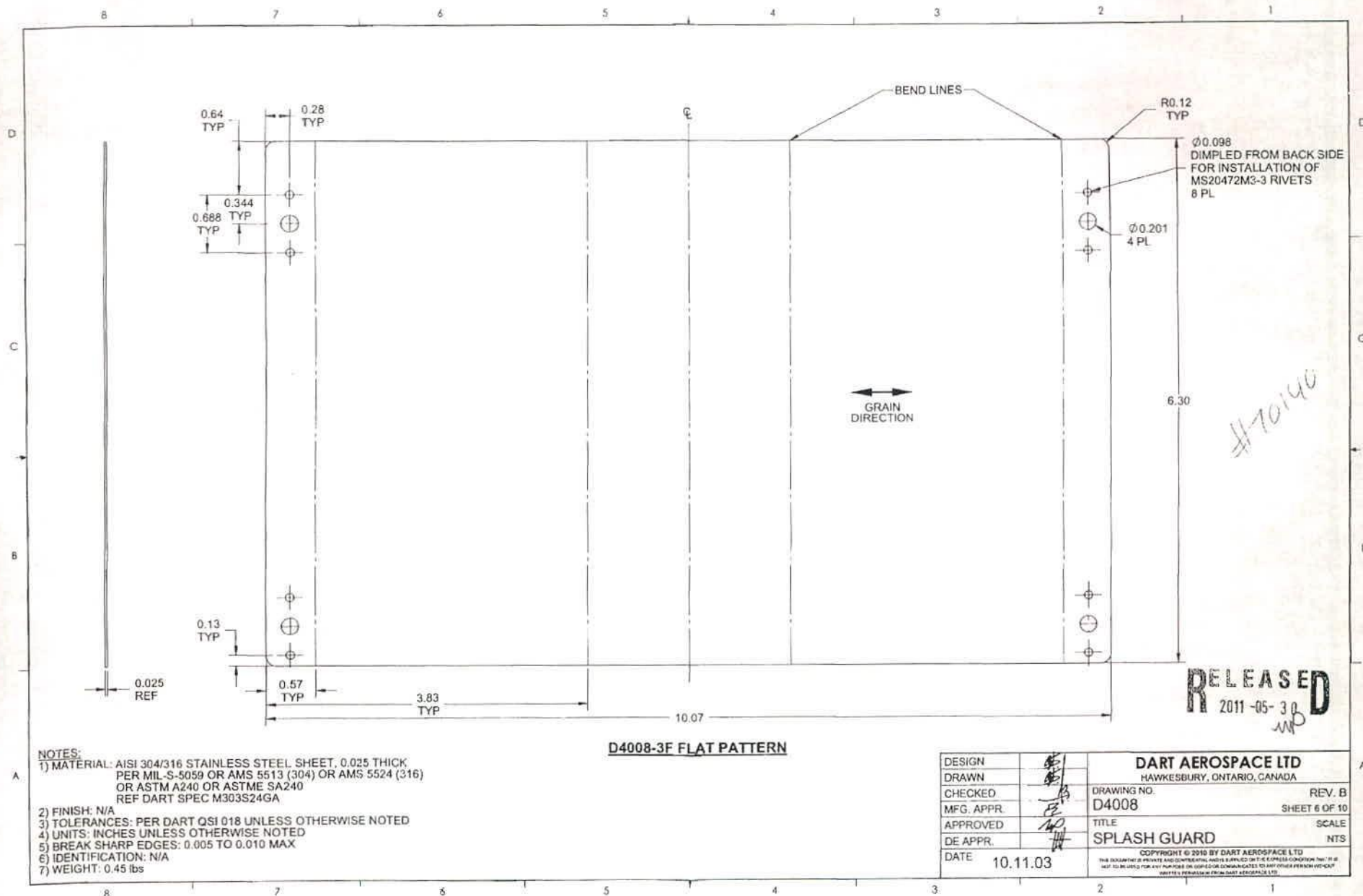


D4008-3 FUEL PUMP SPLASH GUARD COVER

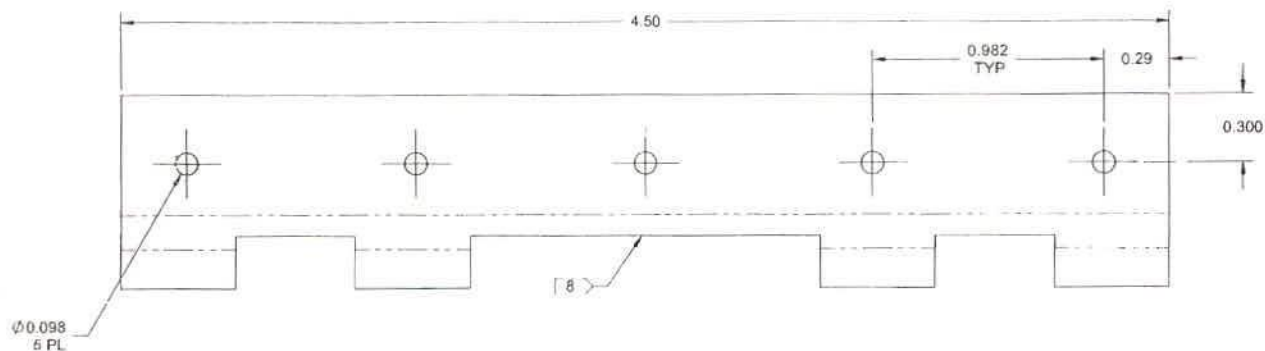
RELEASED
2011-05-30
JW

- NOTES:
- 1) MATERIAL: MADE FROM D4008-3F
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.45 lbs

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MFG. APPR.		D4008	SHEET 5 OF 10
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-5	REF JCA-M47-2-26



D4008-5 HINGE HALF

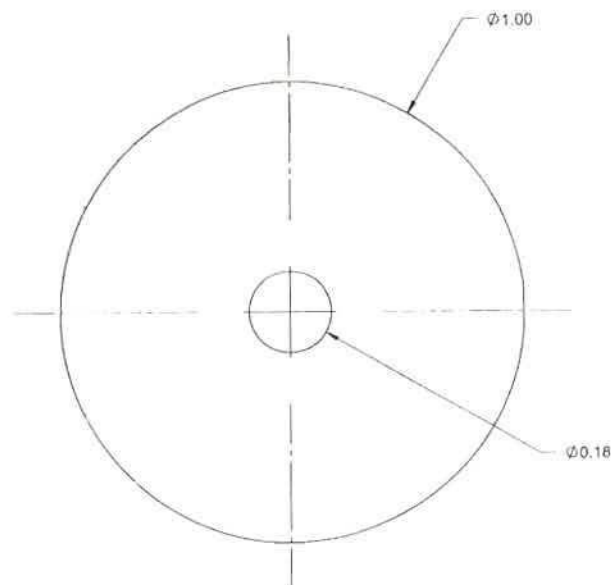
RELEASED
2011-05-30
JNP

NOTES:

- 1) MATERIAL: MADE FROM MS20001-4 HINGE OR MS20257-3 HINGE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs
- 8) REMOVE CENTER LUG FROM THIS AREA, FLUSH WITH THIS EDGE

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4008	SHEET 7 OF 10
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-7	REF JCA-M47-2-26



D4008-7 WASHER

RELEASED
2011-05-30
NM

NOTES:

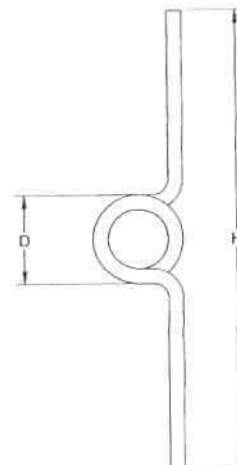
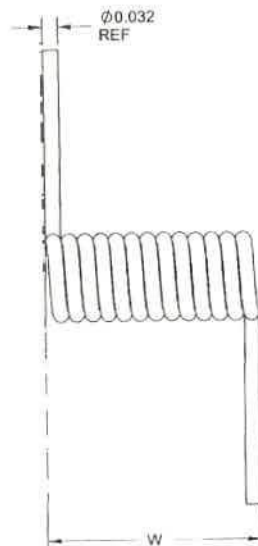
- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, Ø1.00 ROUND BAR, BLACK
REF DART SPEC M-DELRIN-R1.000
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4008	SHEET 8 OF 10
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DART AEROSPACE
PART NUMBER
D4008-9

JOHN CAMERON AVIATION
PART NUMBER
REF JCA-M47-2-26

SPECIFICATION CONTROL DRAWING



#70140

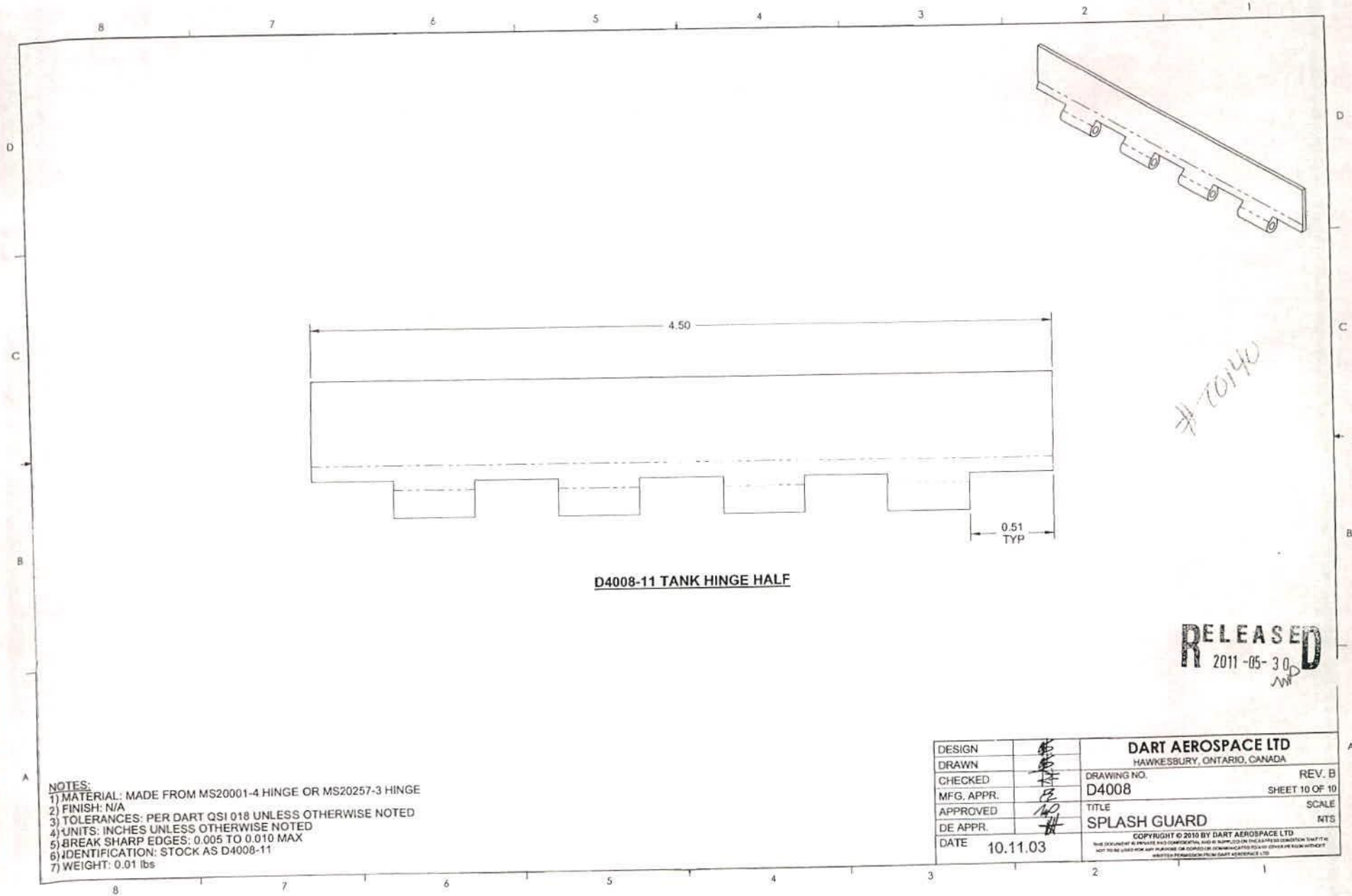
DART P/N	SUPPLIER	SUPPLIER P/N	WIDTH "W"	HEIGHT "H"	DIAMETER "D"	MATERIAL
D4008-9	VICTORY SPRING	N/A	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE
D4008-9	BELL HELICOPTER	206-031-140-001	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE

D4008-X SPRING

RELEASED
2011-05-30
W

- NOTES:
- 1) MATERIAL: T301 OR 304 STAINLESS STEEL SPRING WIRE $\phi 0.032$ PER ASTM A313
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.00 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D4008	REV. B
CHECKED			SHEET 9 OF 10
MFG. APPR.		TITLE SPLASH GUARD	SCALE NTS
APPROVED		DATE 10.11.03	
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D4008-11 TANK HINGE HALF

#70140

RELEASED
2011-05-30
JNP

- NOTES:**
- 1) MATERIAL: MADE FROM MS20001-4 HINGE OR MS20257-3 HINGE
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: STOCK AS D4008-11
 - 7) WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4008	SHEET 10 OF 10
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